

Date: Thursday, 11/9/2006 4:37:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 29392					
Estimate Number	: 11030					
P.O. Number	: N/A			Part Number	: D2803042	
This Issue	: 11/9/2006 S.O. No. : N/A			Drawing Number	: D2803 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 29177			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 11/27/2006	
Checked & Approved By	: <i>[Signature]</i>			Qty:	15 Um: Each	
Comment	: Est F 05:03:30 MS21043-3 was MS21042L3			KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28032	STA 84 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) STA 84 BRACKET Pick: Qty Part Number Description Batch	<i>This batch is net in size</i>
		1 D2803-2 Bracket <i>290104</i>	
2.0	D28052	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) STOP Pick: Qty Part Number Description Batch	<i>mf</i>
		1 D2805-2 Stop <i>B29406</i>	
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) Bushing Pick: Qty Part Number Description Batch	<i>mf</i>
		1 D2809 Bushing <i>B28645</i>	
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2803	<i>mf 06/11/27</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:37:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29392

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M06/11/27

15

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a m 06/11/20 15

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S A M 06:11:30 15

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

S A M 06:12:02 15

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	<i>M10L760</i>

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	<i>10L404</i>

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	<i>100943</i>
A/R	LPS-3	Corrosion Spray	<i>M101472</i>

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

SA M

06:12:30

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:37:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29392

Part Number: D2803042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

SAD 08:12:02

15 ✓

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11/06/12/04

15

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST156x ST157

LB06/12/05

15

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

11/06/12/06

15

Job Completion



C Loc 11/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

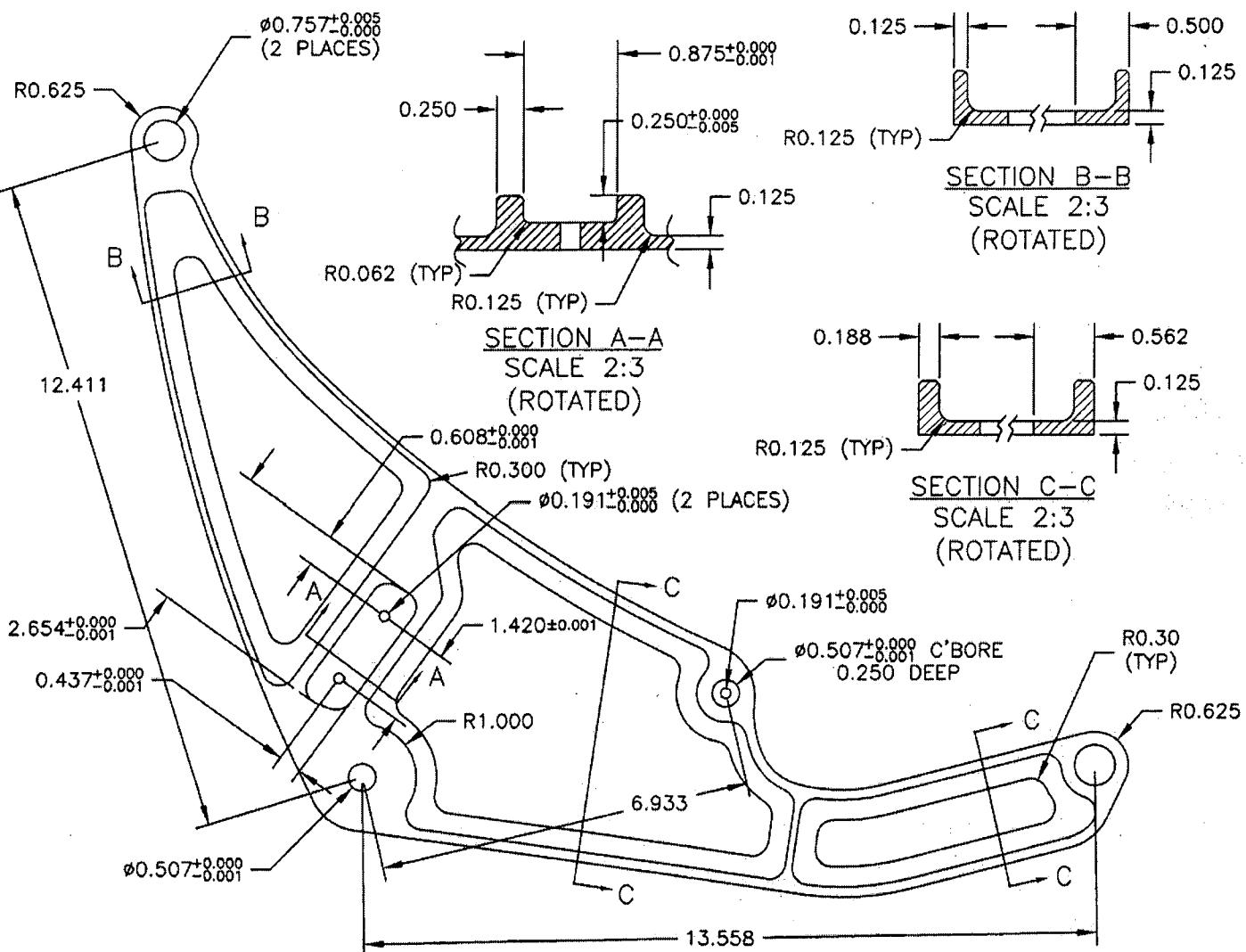
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2	
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3	
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05.03.11 -



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
 - 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
 - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
 - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

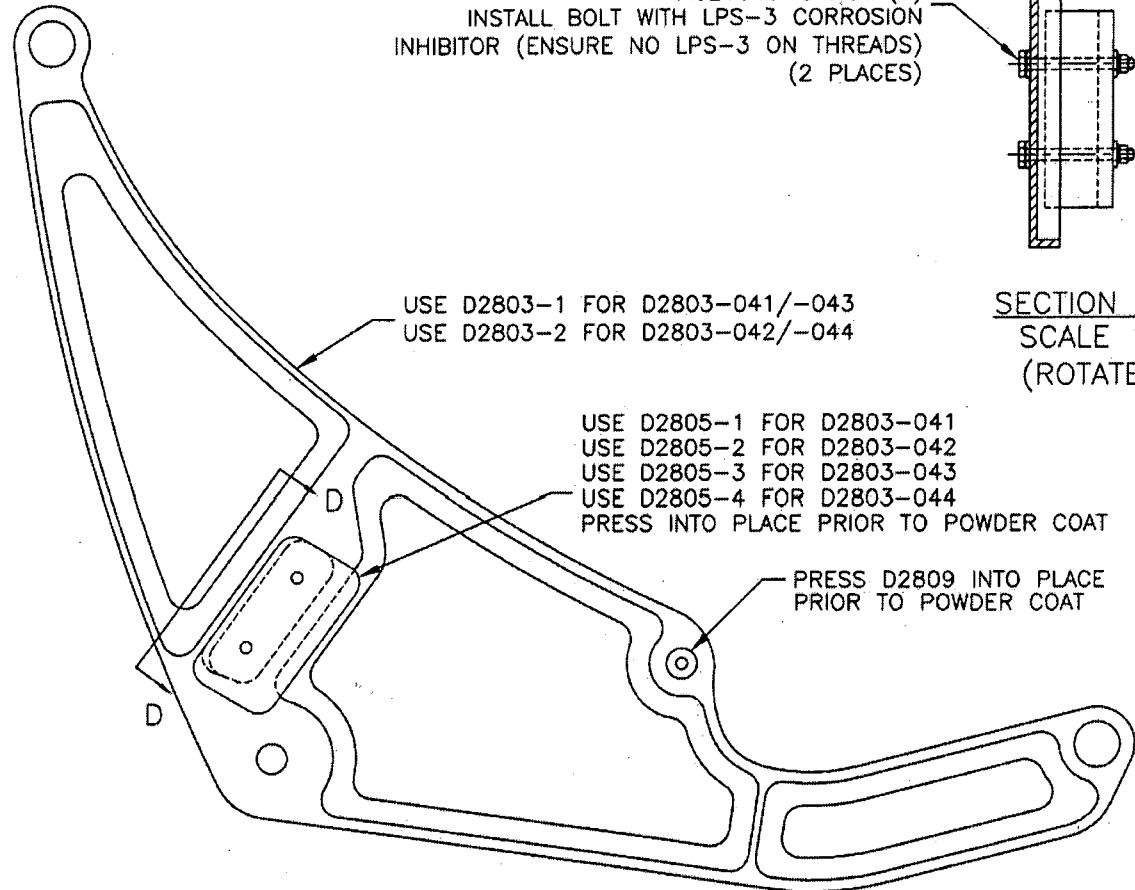
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WITHOUT NOTICE
WORK ORDER
NO. 29392

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:5



D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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WORK ORDER
NO. Z9392